

Date: Thursday, 2/14/2008 2:21:00 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HI-STEP LEG ASSEMBLY
Job Number	: 37452		
Estimate Number	: 10355		
P.O. Number	:	Part Number	: D2582
This Issue	: 2/14/2008 S.O. No. :	Drawing Number	: D2582 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: B
Previous Run	: 36710	Material	:
Written By	:	Due Date	: 2/25/2008
Checked & Approved By	:	Qty:	12 Um: Each
Comment	Est Rev:F Removed Manufacturing 05-11-07 JLM Est Rev:G Added part # to Sub 06-08-10 JLM Est Rev H New pick list 08.01.11 EC verified by: DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	37452A	STEP LEG
-----	--------	----------



X Comment: Sub-Component STEP LEG

D2278 B 37452A

mf

2.0	37452B	STEP SPACER
-----	--------	-------------



Comment: Sub-Component STEP SPACER

D2322 B 37452B

mf

3.0	37452C	STEP SPACER
-----	--------	-------------



Comment: Sub-Component STEP SPACER

D2279 B 22585

mf

4.0	37452D	STEP SPACER
-----	--------	-------------



Comment: Sub-Component STEP SPACER

D3720-1 B 37452D

mf

5.0	37452E	STEP SPACER
-----	--------	-------------



Comment: Sub-Component STEP SPACER

D3720-2 B 37452E

mf

08-03-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 08/03/06

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 2:21:00 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 37452

Part Number: D2582

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS20470AD44

Rivet, Universal Head



Comment: Qty.: 22.0000 Each(s)/Unit Total : 264.0000 Each(s)

Pick:

Qty Part Number Description Batch

22 MS20470AD4-4 Rivet M106654

mf

7.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS20470AD4-5 Rivet M104156

mf

08-03-06

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2582 and

mf

08-03-06

(12)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/06 (12)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA27

PE

08-03-06

12

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/06

(12)

Job Completion



mi 2008/3/06

(12)

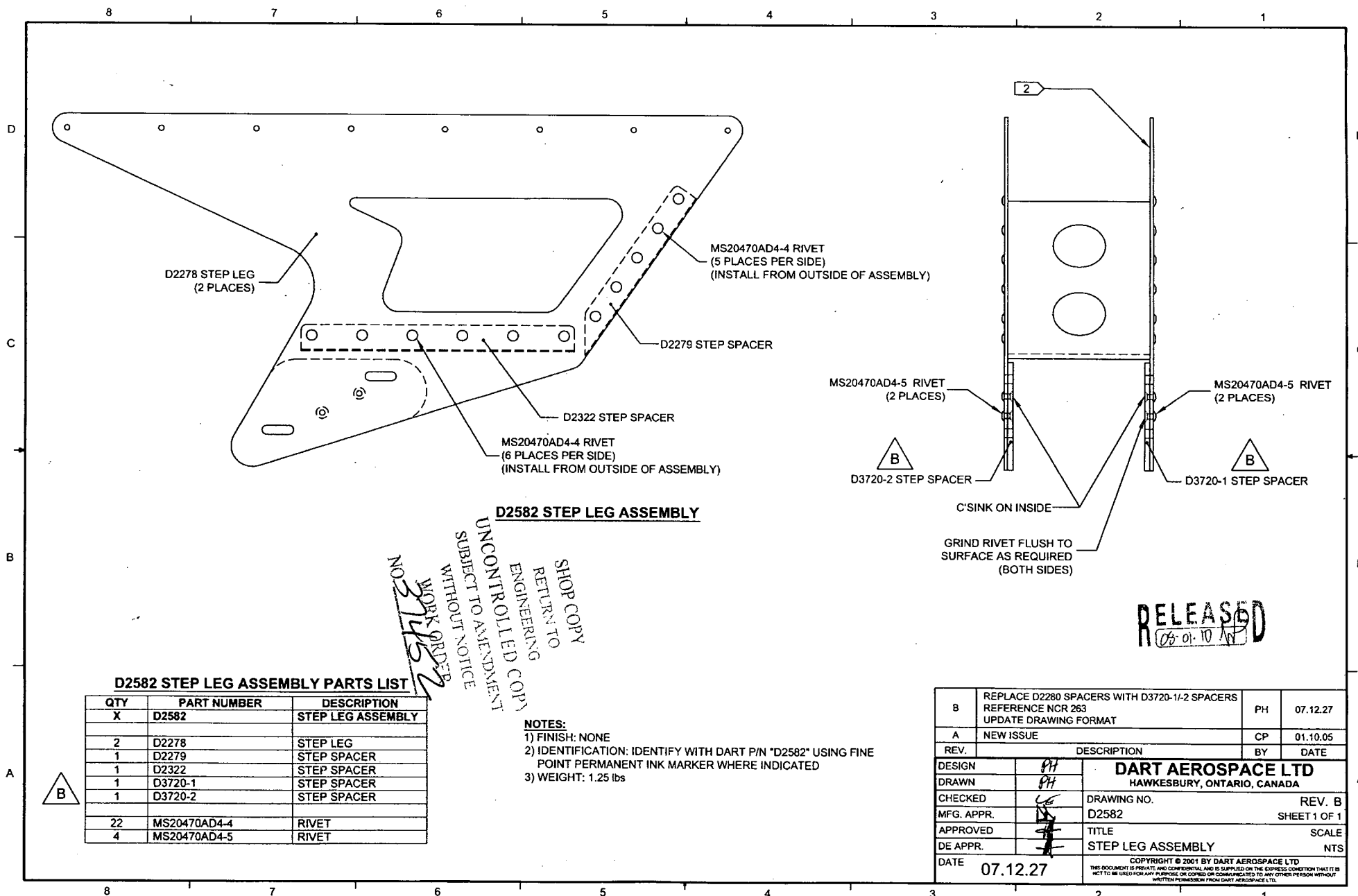
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____










NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries



Date: Thursday, 2/14/2008 2:21:01 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP LEG
Job Number	: 37452A		
Estimate Number	: 10353		
P.O. Number	:	Part Number	: D2278
This Issue	: 2/14/2008 S.O. No. :	Drawing Number	: D2278 REV F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: F
Previous Run	: 36710A	Material	:
Written By	:	Due Date	: 2/25/2008 Qty: 24 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now 6061-T6 06-06-23 JLM Est Rev C New flat pattern 08.01.11 EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S080	6061-T6 .080 Sheet	
		32	
Comment: Qty.: 1.0306 sf(s)/Unit Total : 24.7338 sf(s) Material: 6061-T6 sheet (QQ-A-250/8) 0.080" Thick (M6061T62S.080) Identify as D2278 Batch: 107276 IB 8-3-3			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET 1-Cut as per Dwg D2278 Dwg Rev: F IB 8-3-3 Prog Rev: F 2-Deburr if necessary IB 8-3-3			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		IB 8-3-3	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK 5 09/09/09 (31) correct			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: 15 Date: 08/03/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 2:21:01 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 37452A

Part Number: D2278

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

4/

08-03-04

(V3)

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf

08-03-06

(31)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

mf

08-03-06

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(31)

Comment: FINAL INSPECTION/W/O RELEASE

20080306

Job Completion



in 2008/3/06

(31)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

